

Work Order ID 71591

Wednesday, July 06, 2011 1:26:39 PM



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Item ID: D2564

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Angle

Start Date: 7/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/07/13 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2564	Rev B1

100	BAND SAW	0.00							
	Bandsaw	Memo	0.00						
Jeaspa Bandsaw	Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)								

11/07/13

30

110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	Memo	0.00						
HAAS CNC vertical machine #1	1- Mill as per Folio FA276 Rev: _____ & Dwg D2564 Rev: _____ 2- Deburr if necessary								

11/07/13

30

Manual Mill

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo	0.00						
Quality Control									

11/07/13

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 71591

Parent Item: D2564

Parent Item Name: Mounting Angle



Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐D☐02.09.09☐Re-format; Added FA276 Folio☐KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6207		Manufactured	No			100	f	0.0000	0.0916	1.928421			



Angle Extrusion

16061 T6 Al. w. 125

M115776



2.8 f 11/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

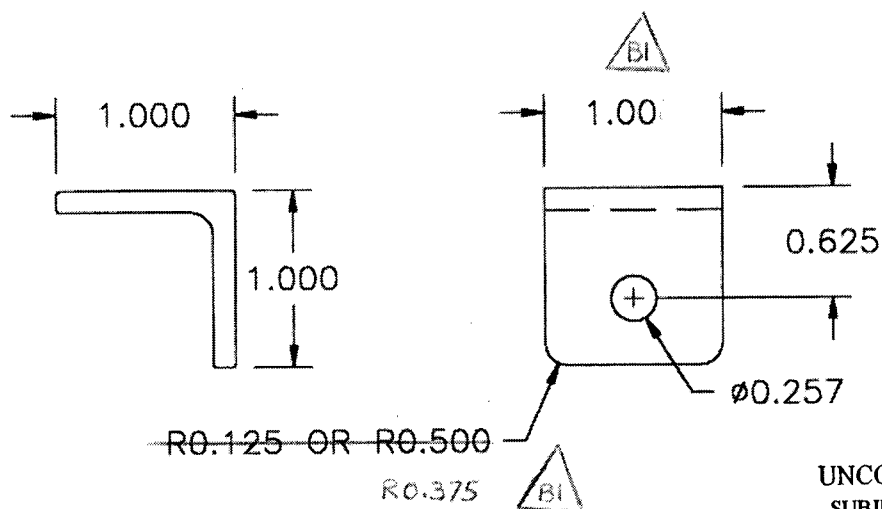
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M		MIKE M		DRAWING NO. D2564	REV. B
CHECKED BW		APPROVED BW			SHEET 1 OF 1
DATE 96:04:30		TITLE MOUNTING ANGLE			SCALE 1:1
B	97:05:06		MODIFIED DIMENSIONS		
BI	02.09.17		R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000		

RELEASED
97/05/06 BW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71591

CL11107/06

NOTES

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

